Work Order ID 65898

QC

Quality Control

Thursday, January 27, 2011 7:17:58 AM

Item ID: D3477-041 Accept Setup Start **Revision ID:** Stop Blower Motor Inlet Adapter Item Name: Start Date: Start Qty: 2.00 1/27/2011 **Cust Item ID:** Required Date: 2/1/2011 Req'd Qty: 2.00 **Customer:** Reference: Start Run Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3477 Rev B 100 0.00 Small Fab Small Fab 0.00 Memo Small Fab 1-Assemble as per Dwg D3477 2-Spot Weld as per Dwg D3477 and Dart QSI 004 110 QC11- Inspect spot weld per QS1004 0.00 QC 0.00 Memo Quality Control 120 QC5- Inspect part completeness to step on W/O 0.00

0.00

Memo

										
W/O:			W	ORK ORDER CHANG	GES			-		
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section		Chief Eng	QC Inspector
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Work Order ID 65898

Thursday, January 27, 2011 7:17:58 AM

Item ID: D3477-041 Accept Setup Start **Revision ID:** Stop Item Name: Blower Motor Inlet Adapter Start Qty: 2.00 **Start Date:** 1/27/2011 **Cust Item 1D:** Required Date: 2/1/2011 Req'd Qty: 2.00 **Customer:** Reference: Start Approvals: **Process Plan: Tooling:** Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject **Work Center ID** Description Qty Number Stamp **Run Hours** Code Qty Identify as per dwg & Stock Location: 130 0.00 Packaging 0.00 Memo Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

M/02/04/1/ MK 11-02-07

Insp.

Dart Aeı	rospace	e Ltd			-					
W/O:			V	ORK ORDER CH	ANGES					•
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Ca	tegory:	NCF	R: Yes	No DQ	A:	Date:	
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descrip	Section B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
·-		Section A	Chief Eng	Chief Eng		Date	3601	ion C	Office Eng	QO IIISPECIOI
<i>y</i>										
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Picklist Print

Thursday, January 27, 2011 7:17:55 AM

Work Order ID: 65898

Parent Item:

D3477-041

Parent Item Name: Blower Motor Inlet Adapter

Start Date: 1/27/2011

Required Date: 2/1/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

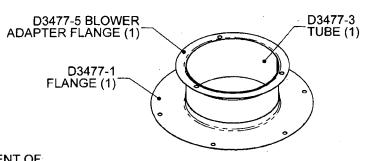
IPP Rev: A New Issue 06-02-03 JLM

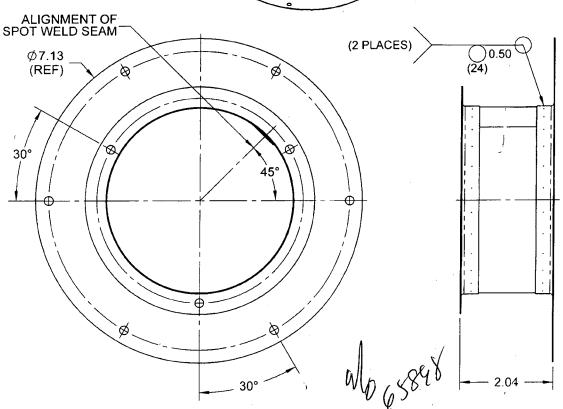
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Statu Issued
D3477-1		Manufactured	No			100	Each	0.0000	1	2	5k 11	102/02
							B65	899				, ,
Flange												
D3477-3		Manufactured	No			100	Each	6.0000	I	2		ſ
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Tube												(
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				ST155			6			···		
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D3477-5		Manufactured	No			100	Each	8.0000	l	2		
Blower Adapter Flange												
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code				
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W/O:			W	ORK ORDER CHANG	ES	···		· · · · · · · · · · · · · · · · · · ·
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Part No	:	PAR #:	Fault Ca	legory:	NCR: Yes	No DQA:	Date: _	
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NCR:			WORK OR	DER NON-CONFORMA	NCE (NCI	₹)		
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
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DESIGN	4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	ED	APPROYED	DRAWING NO.	REV. B
P	H	- HI	D3477 _{SH}	EET 1 OF 4
DATE			TITLE	SCALE
	08.1	2.19	BLOWER INLET ADAPTER	1:2
Α	0:	5.12.09	NEW ISSUE	
В	0:	8.12.19	ϕ 3.40 & ϕ 4.1 WERE ϕ 3.600 & ϕ 4.14 (SHT 2 & 4); ADD MFG NOTE AND TOL MATL SPEC WAS MIL-S-5019	(SHT 3);





D3477-041 BLOWER MOTOR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 1) SPOT WELD PER DART QSI 004
 2) FINISH: NONE
 3) IDENTIFY WITH DART P/N D3477-041 USING
 FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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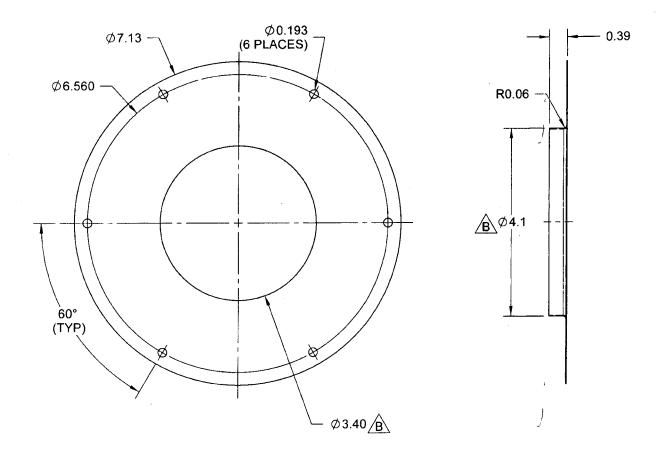
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DATE		TITLE		SCALE
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Marke M



D3477-1F FLANGE FLAT PATTERN

65898

D3477-1 FLANGE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

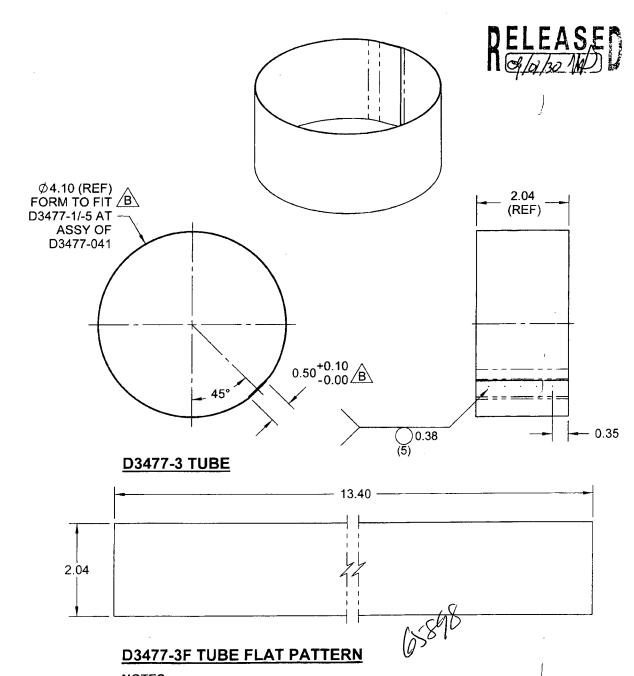
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DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3477 SH	REV. B EET 3 OF 4
DATE 08.	12.19	BLOWER INLET ADAPTER	SCALE 1:2



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) WELD PER DART QSI 004
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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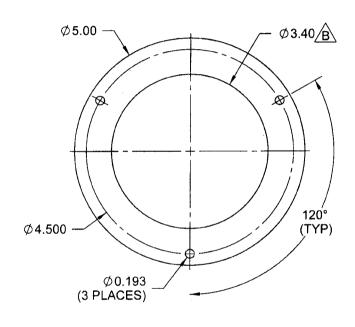
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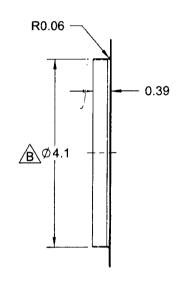
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DATE	OTED	Description of NC		Corrective Action Section	ion B		Verif	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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CHECKED	APPROVED	DRAWING NO. D3477	REV. B SHEET 4 OF 4
DATE 08	.12.19	BLOWER INLET ADAP	TER 1:2

RELEASED





D3477-5F FLAT PATTERN

D3477-5 BLOWER ADAPTEF: FLANGE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD AMS-W-6858A CLASS 'C'

	TEST NOH: 42				
EMPLOYEE: Mare Dragon	}				
PART NUMBER: 03437-04/	JOB NUMBER: 1545898				
MATERIAL TYPE:	MATERIAL THICKNESS: (-1)				
GROUP SPECIFICATION □ □ □ □	Group 1: Aluminum & magnesium Group 2: Iron; nickel; cobalt Group 3: Titanium				
TEST 1	RESULTS				
PASS FAII VISUAL: [] [PENETRATION: [- /] [PULL STRENGTH: [/] [
Qualified in accordance with standard A DATE OF TEST COUPON: 11 (03/02) QUALIFIER:	AMS-W-6858A and QSI 004 (ref: 4.3)				